

Work Order ID 65073 -2

Thursday, January 06, 2011 10:38:47 AM

Page 1

Item ID: D3235-1

Revision ID:

Item Name: Mounting Lug

Start Date: 1/6/2011 Start Qty: 100.00

Required Date: 1/13/2011 Req'd Qty: 100.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date: 10-1-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3235	Rev A

100	BAND SAW	0.00
Bandsaw		
Jeaspa Bandsaw		
	Memo	0.00
	Cut D2423 extrusion to 0.820"	
	Batch:	
	cut @ metec	

CL 1/10/07

110	HAAS CNC VERTICAL MACHINING #1	0.00
HAAS 1		
HAAS CNC vertical machine #1		
	Memo	0.00
	1-Machine as per Folio FA369 and Dwg D3235	
	2-Identify as D3235-1	
	3-Deburr	

CL 1/10/07 (100)

issue 710.

to metec machine as per dwg D3235 REV. A

120	QC2-Inspect parts off machine FA/PATB	0.00
QC		
Quality Control		
	Memo	0.00

we'd + inspect after transit damage.

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Item ID: D3235-1

Accept



Setup Start



Revision ID:

Item Name: Mounting Lug

Stop



Start Date: 1/6/2011 Start Qty: 100.00



Cust Item ID:

Required Date: 1/13/2011 Req'd Qty: 100.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

160

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 10:15
OVEN TEMPERATURE: 320°
FINISH TIME: 10:45

COINTEL
+85

Y85 0 11-2-24

65 BR 11-2-24

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Item ID: D3235-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Mounting Lug

Start Date: 1/6/2011 Start Qty: 100.00

Cust Item ID:

Required Date: 1/13/2011 Req'd Qty: 100.00

Customer:

Reference:

Run Start

Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

Stop

QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

11/2/24 sf (852)

180

Identify as per dwg & Stock Location: 471

0.00



Packaging

Memo

0.00

Packaging

11/2/24 sf (852)

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/02/24 sf

MF

11-02-24

Picklist Print

Page 1

Thursday, January 06, 2011 10:38:51 AM

Work Order ID: 65073



Parent Item: D3235-1



Parent Item Name: Mounting Lug





Start Date: 1/6/2011

Required Date: 1/13/2011

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP ☐ A ☐ 04.04.19 ☐ New issue ☐ KJ/JLM ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3235-IP		Purchased	No			100	Each	0.0000	1	100			
													
Lug													
D2423		Manufactured	No			110	f	534.1914	0.0683	7.189474			
													
Lug Extrusion													

CL 1/10/07

Location

MAT06

43722
45800
63005

Loc Qty

534.1914265
180
66.1914265
288

Loc Code

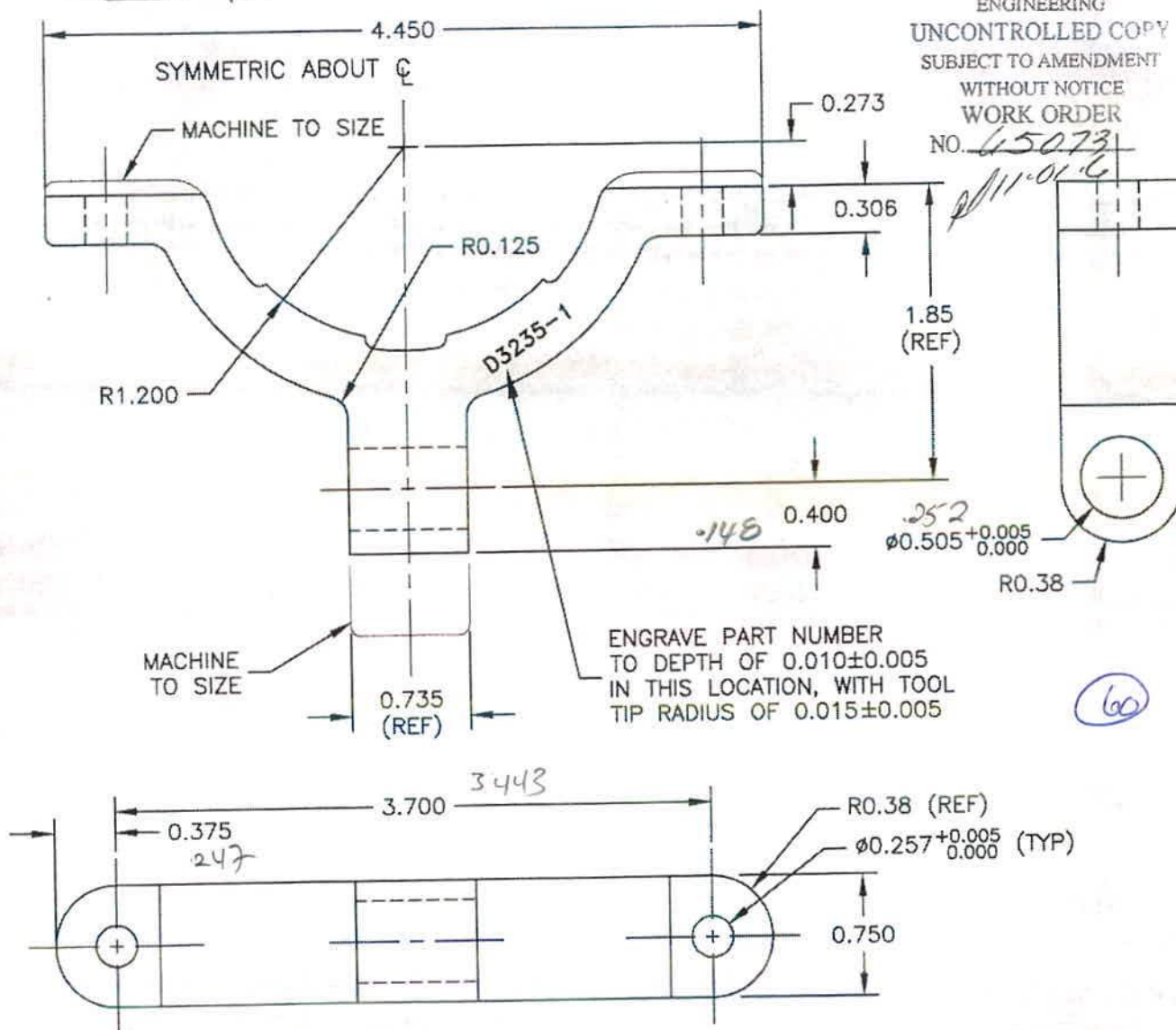
7.18947400000000

DART

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3235	REV. A SHEET 1 OF 1
DATE 04.03.02		TITLE MOUNTING LUG	SCALE 1:1
A	04.03.02	NEW ISSUE	

RELEASED
040405 *#*

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *65073*
11-01-06

**D3235-1 MOUNTING LUG**

MAKE FROM EXTRUSION D2423

BREAK ALL EDGES 0.000-0.015

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO13246

Purchase Order Date 1/07/11

PO Print Date 1/07/11

Page Number 1 of 1

Order From : VC-MET003

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, QC K0B 1R0
CA

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	613 678 3957	Requisition Nbr	
Vendor Fax	613 678 3956	Tax Resale Nbr	10127-2607
Vendor Account Nbr		Terms	Net 30
		Currency	CAD
		FOB	Destination-Collect

Order To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

PAID
C/L 1/10/11

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
D2230-3P		LUG	1/18/11 Yes	100.00 Each	Yours ppd	\$10.4000	\$1,040.00
		Special Inst:	AS PER DWG D2230 REV. G B65067				
D3235-1P		lug	1/18/11 Yes	100.00 Each	Yours ppd	\$13.9000	\$1,390.00
		Special Inst:	AS PER DWG D3235 REV. A B65073				
			PO Total: \$2,430.00				

CERTIFICATE OF CONFORMITY
REQD UPON DELIVERY

Change Nbr: 1

Change Date: 1/07/11

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

85

D3235-1

Mounting Lug

13246

MATERIAL: supplied by DART D2423 B45800

S
11/02/18

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.



Fabian Kueffer

Vankleek Hill, February 18, 2011